

Work Order ID 59305 -1

Monday, May 31, 2010 1:02:49 PM

Page 1

SPLIT

Item ID: D3572-041

Accept

Setup Start

Revision ID:

Stop

Item Name: Guide Assembly

Start Date: 5/31/2010 Start Qty: 10.00

Cust Item ID:

Required Date: 6/7/2010 Req'd Qty: 10.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-5-31

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3572

Rev D

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

EZ 10-6-3 (X10)

110

Small Fab

0.00



Small Fab

Memo

0.00

Small Fab

1-Cut Tube D3572-1 as per Dwg D3572
2-deburr both ends

EZ 10-6-3 (X10)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

Split

(X10)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 59305

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Item ID: D3572-041

Accept



Setup Start



Revision ID:

Stop



Item Name: Guide Assembly

Start Date: 5/31/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 6/7/2010 Req'd Qty: 10.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

130



Large Fab

Weld per dwg A/R Aluminum rod Batch: _____
Large Fab *M112860*

0.00

Memo

0.00

1-Weld D3572-3 guides and D3572-5 bracket as per Dwg D3572
2- grind weld flush at the end of tube only*FL 10-6-7* *(XS)*

140



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

BE 10/06/07 *(XS)*

150



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

0.00

Memo

0.00

*S1066108**(XS)*

W/O:		WORK ORDER CHANGES					
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Work Order ID 59305

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Item ID: D3572-041	Accept		Setup	Start	
Revision ID:				Stop	
Item Name: Guide Assembly					
Start Date: 5/31/2010	Start Qty: 10.00		Cust Item ID:		
Required Date: 6/7/2010	Req'd Qty: 10.00		Customer:		
Reference:					

Approvals:	Process Plan: _____	Date: _____	Tooling: _____	Date: _____	Run	Start	
	QC: _____	Date: _____	SPC (Y/N): _____	Date: _____		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
180 HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00							
190 Powdercoat Powder Coating	Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3 M112588 Memo START TIME: 11:45am OVEN TEMPERATURE: 320° F FINISH TIME: 12:15pm	0.00 0.00		→ M 10/06/10					
200 QC Quality Control	QC3- Inspect Part Finish Memo	0.00 0.00							

W/O:		WORK ORDER CHANGES					
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Setup Start



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Start Date: 5/31/2010 Start Qty: 10.00



Cust Item ID:

Required Date: 6/7/2010 Req'd Qty: 10.00



Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start



QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

210

Identify as per dwg & Stock Location

260

0.00



Packaging

Memo

0.00

Packaging

10-6-11

SP

8x

220

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/14

CZ10/6/11

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Monday, May 31, 2010 1:02:55 PM

Page 1

Work Order ID: 59305

Parent Item: D3572-041

Parent Item Name: Guide Assembly

Comments: IPP Rev:A New Issue 07-02-07 JLM
 IPP rev B revB dwg EC
 IPP Rev:C Removed D3572-7 Cap 07-06-11 JLM
 IPP Rev:D 08-05-27 Review process of IPP DD verified by:EC

Start Date: 5/31/2010

Required Date: 6/7/2010

Start Qty: 10.00

Required Qty: 10.00

M6061T6T1.000W.188

Purchased No

110

f

98.1240

2.34

24.63158



EL 10-6-3

6061T6 RD TUBE 1.00 X .188W

Location

Loc Qty

Loc Code

MAT

24.375

114520

24.375

11.4.

MAT016

73.749

113511

26.916

11.4

114089

46.833

D3572-3

Manufactured No

130

Each

0.0000

4

40



EL 10-6-3

Guide

B59142 X ~~35~~ 35

D3572-5

Manufactured No

130

Each

18.0000

1

10



Q 10-6-3

Bracket

Location

Loc Qty

Loc Code

WA

18

54119

18

~~9~~ 9

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

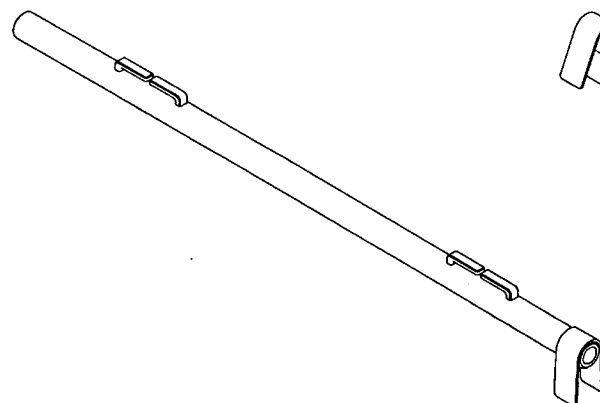
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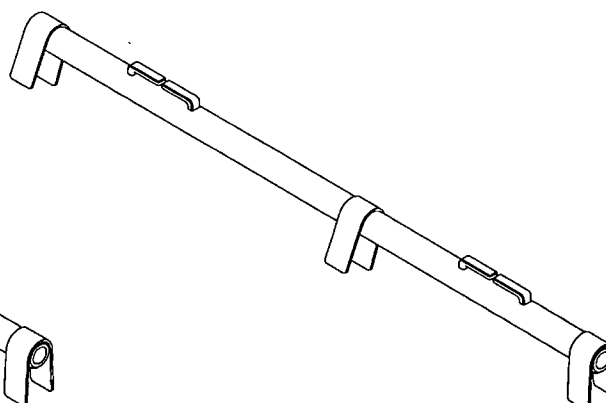
ITEM No.	QTY -041	QTY -043	QTY -044	PART NUMBER	DESCRIPTION
1	X			D3572-041	GUIDE ASSEMBLY
2		X		D3572-043	GUIDE ASSEMBLY (UH-1)
3			X	D3572-044	GUIDE ASSEMBLY (UH-1) (OPP)
11	1	1	1	D3572-1	TUBE
12	4	4	4	D3572-3	GUIDE
13	1	3	3	D3572-5	BRACKET
14	-	-	-	D3572-7	DELETED AT REV C

SI
R
ENG
UNCONTROL
SUBJECT TO A
WITHOUT N
WORK ORL
NO. 59305
pro-5-3

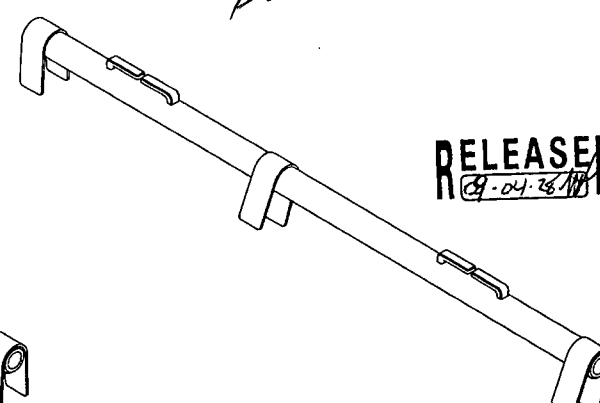
RELEASED
09-04-28/11



D3572-041 GUIDE ASSEMBLY



D3572-043 GUIDE ASSEMBLY (UH-1)



D3572-044 GUIDE ASSEMBLY (UH-1)

NOTES:

- 1) MATERIAL: NONE
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT GREY SANDTEX (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3572-XXX" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT -041: 1.34 lbs
-043/-044: 1.42 lbs
- 8) WELDING: PER DART QSI 004

D	REDRAWN IN "B" SIZE FORMAT TO CURRENT STANDARDS. ADD -043, -044 FOR UH-1. SEE PAR 09-017.	AJS	09.04.17
C	REMOVE D3572-7	LE	07.06.01
B	FOR D3573-3 0.03 CHMF WAS 0.06; ADD TYP TO FILLET	LE	07.04.20
A	NEW ISSUE	LE	07.03.29
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. D
MFG. APPR.	<i>[Signature]</i>	D3572	SHEET 1 OF 4
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	GUIDE ASSEMBLY	NTS
DATE	09.04.17	COPYRIGHT © 2007 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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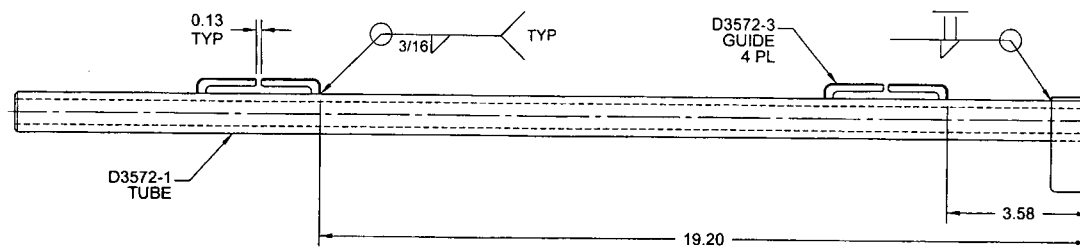
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

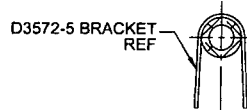
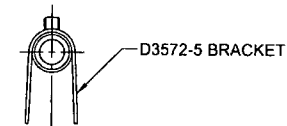
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NOTE: Date & initial all entries

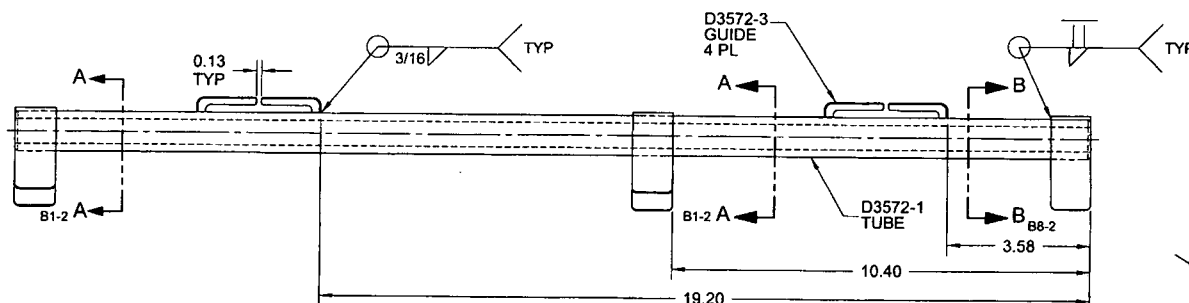
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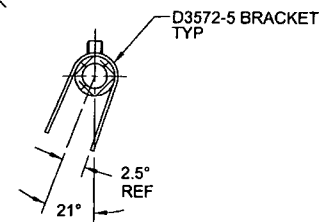
D3572-041 GUIDE ASSEMBLY



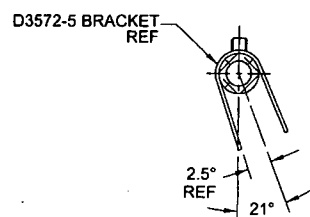
SECTION B-B C2-2



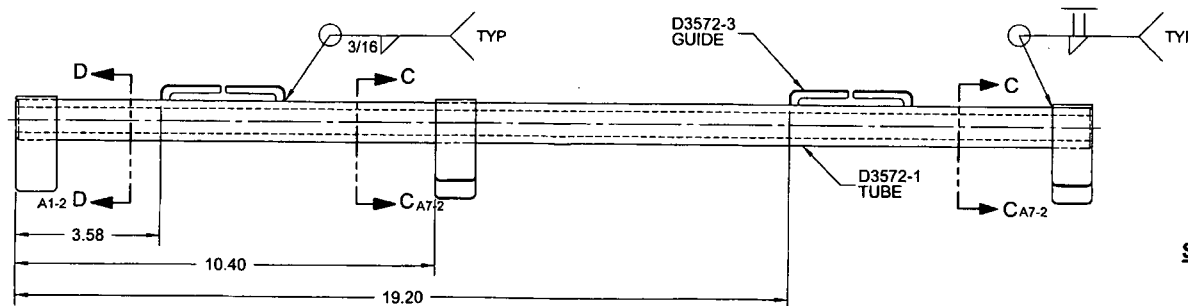
D3572-043 GUIDE ASSEMBLY



SECTION A-A C7-2
C4-2
(2 PL)

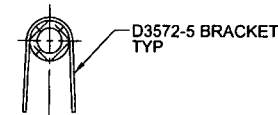


SECTION C-C A2-2
A5-2



D3572-044 GUIDE ASSEMBLY

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09-04-17



SECTION D-D A7-2

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w/o 59306

8 7 6 5 4 3 2 1

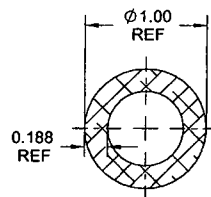
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

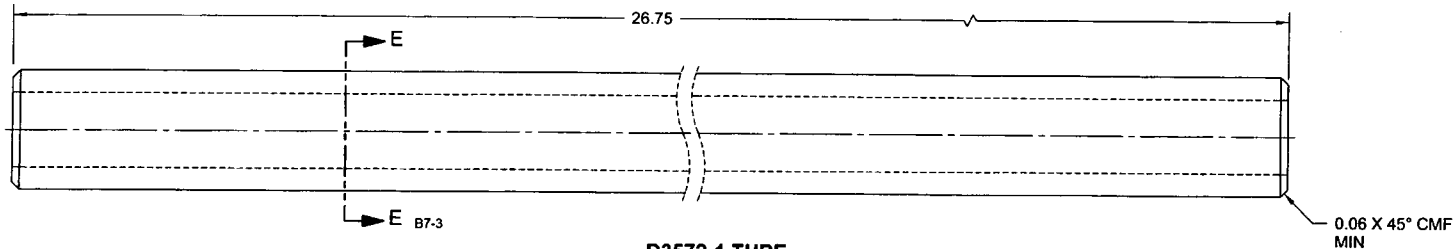
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SECTION E-E C5-3



D3572-1 NOTES:

- 1) MATERIAL: 6061-T6 (T62) ALUMINUM TUBE 1.00 OD X 0.188 WALL
PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR AMS-QQ-A-225/8
REF DART SPEC M6061T61.000W.188
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 1.25 lbs

W/L 59305

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09/04/17

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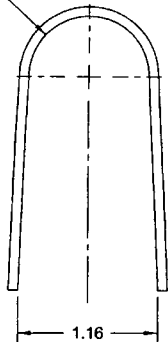
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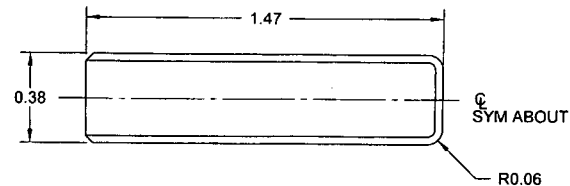
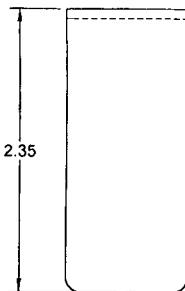
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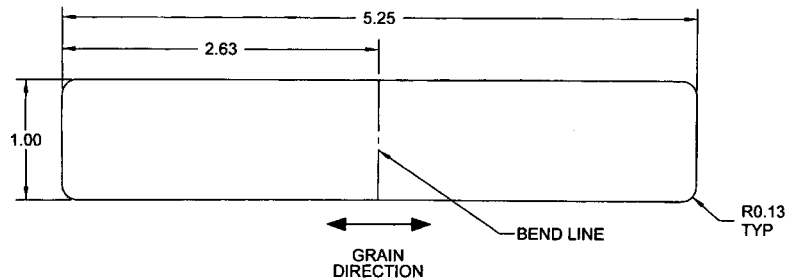
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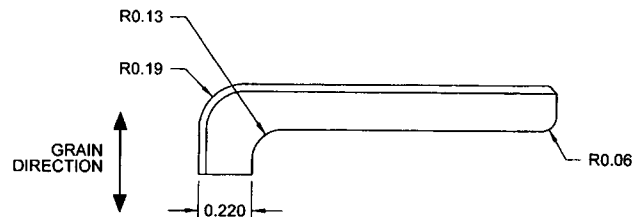
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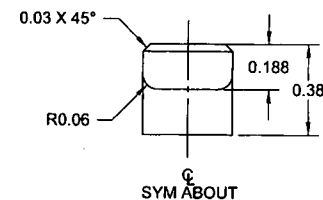
D3572-5 BRACKET
(MAKE FROM D3572-5F)



D3572-5F FLAT PATTERN



D3572-3 GUIDE



RELEASED
9/04/13

D3572-3 NOTES:

- 1) MATERIAL: 6061-T6 (OR T651/T6510/T651/T62) ALUMINUM BAR
PER AMS-QQ-A-225/8 (OR AMS 4117/4128/4115/4116) OR
AMS-QQ-A-200/8 (OR AMS4160)
REF DART SPEC M6061T6B
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

D3572-5 NOTES:

- 1) MATERIAL: 6061-T6 (OR T62) ALUMINUM SHEET 0.080 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
REF DART SPEC M60601T6S.080
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.04 lbs

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AS		
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MFG. APPR.	J	D3572	SHEET 4 OF 4
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